

Work Order ID 73394

Wednesday, August 31, 2011 3:04:09 PM



Page 1

Item ID: D3537-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearpad					
Start Date: 8/31/2011	Start Qty: 50.00		Cust Item ID:		
Required Date: 9/16/2011	Req'd Qty: 50.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/08/31</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	- Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100
 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr
 304 .063 if necessary

B11-9-12

(60)

110
 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

B11-9-12

120
 QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

counts

(760)

54602/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(60)			
Brake NC	Memo 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	0.00							
140 Large Fab	Large Fab	0.00							
Large Fab	Memo Qty Description Batch A/R 2059B Hardcoat 118807 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary	0.00							
150 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							

S 1169113

X60 11-09-16 JBL

S 1169116

ccent
(X60)

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 works

*count
x60*

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00

OVEN TEMPERATURE:

FINISH TIME:

8:30

box of m/f 11/04/21

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

60 BL 11-9-21

M117338

32001

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *FP-2*

0.00



Packaging

Memo

0.00

Packaging

60 BR 11-9-21

200

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/21

MF 11-09-21

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Picklist Print

Wednesday, August 31, 2011 3:04:06 PM

Page 1

Work Order ID: 73394



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

129.1000

0.106

5.578947

65



11-9-12

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

118217

60

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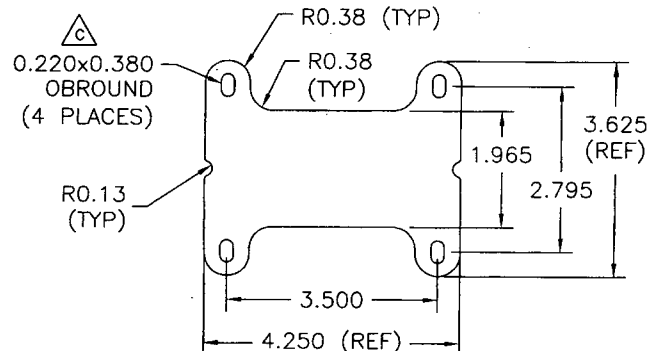
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

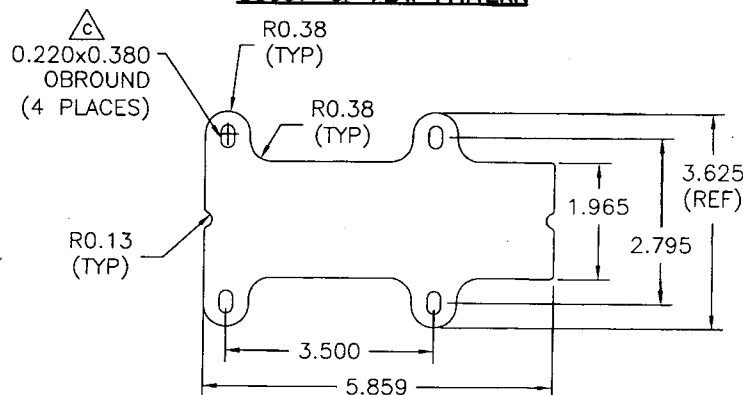
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D3537-1F FLAT PATTERN

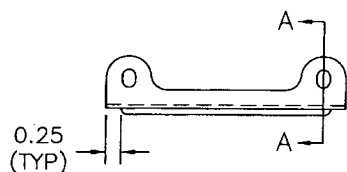


D3537-3F FLAT PATTERN



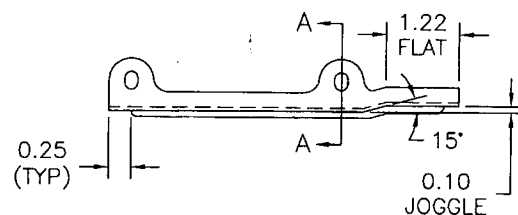
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



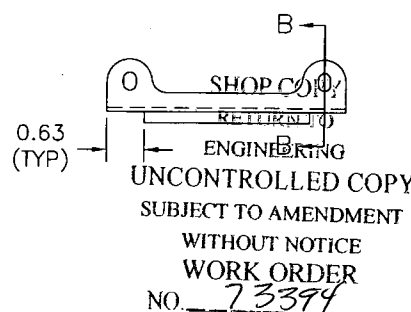
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND

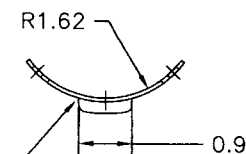
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

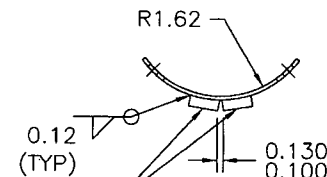
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

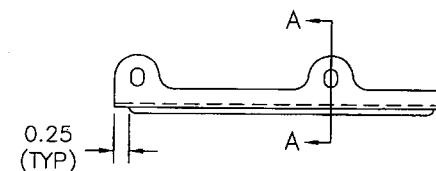
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED	4	APPROVED	4	DRAWING NO.	REV. C
		DATE	07.04.13	TITLE		D3537	SHEET 1 OF 1
				WEARPAD		SCALE	1:2

RELEASED
07.05.08 AM
per ECN 962

W/O:		WORK ORDER CHANGES					
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